



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5354-042
Job Sheet 174732-A



Part No: D5354-042

Job Qty: 2 ea

Part Name: R66 Fwd Clamp Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/2/18

Job Tracking No:

Due Date: 4/20/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C SHEETS 2,4 IPP REV.A New issue 16/07/08 JFS Verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
155	QC	2 pcs		4/20/18	0.00	0.00	QC5		
160	Small Fab	2 pcs		4/20/18	0.00	0.92	Small Fab-9		
170	QC	2 pcs		4/20/18	0.00	0.00	QC5		
180	Packaging	2 pcs		4/20/18	0.00	0.00	Packaging3-2	St 157	
190	QC21-SA	2 Ea		4/20/18	0.00	0.00	QC21		

Part Op 155 - QC5- Inspect part completeness to step on W/O

Descriptions: 160 - -Assemble as per dwg. -Secure nuts as per dwg. (Note #8) -Apply proseal as per dwg. (Note #9)

Batch: _____ Exp. date: _____

170 - QC5- Inspect part completeness to step on W/O

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5316-1	T-Bolt Strap	2 Ea (1 ea)	160-Small Fab	
D5351-1	T-Bolt Spacer	4 Ea (2 ea)	160-Small Fab	
MS21043-3	Nut	4 Ea (2 ea)	160-Small Fab	
NAS1149D0332J	Washer	4 Ea (2 ea)	160-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
160-Small Fab	D5316-1	2	18	0
	D5351-1	4	9	0
	MS21043-3	4	1,248	0
	NAS1149D0332J	4	2,833	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																	
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																															
Description Work Order Deviation		Disposition		Completed By																																															
				Lead hand / Supervisor Approval Verification																																															
				QC / QA Coordinator Approval																																															
Root Cause <table style="width: 100%;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
Environment	☐	No Re-verification	☐																																																
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Dart Aerospace Ltd.
 1270 Aberdeen Street
 Cambridge, ON K6A 1K7
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 Email: sales@dartaero.com
 www.dartaerospace.com



Container No: S067777
 Part: D5354-042
 Job No: 174732-A
 Revision: 1
 Inspector:

Marks/Chatc.

OTHER :

Date: 05/03/18



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5354-042
Job Sheet 174732



Part No: D5354-042

Job Qty: 2 ea **5**

Part Name: R66 Fwd Clamp Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/20/18

Job Tracking No:

Due Date: 4/20/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV C SHEETS 2,4 IPP REV.A New issue 16/07/08 JFS Verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	4/20/18	4/20/18	0.00	0.00	Start Up Machining-4		
100	Bandsaw	2 pcs	4/20/18	4/20/18	0.00	0.01	Bandsaw1		
110	CNC Vertical Machining	2 pcs	4/20/18	4/20/18	0.00	4.65	HAAS1-2 HAAS 5 AXIS		
120	QC	2 pcs	4/20/18	4/20/18	0.00	0.00	QC2 Machining-4		
130	QC	2 pcs	4/20/18	4/20/18	0.00	0.00	QC8 Machining-4		
140	Outsource	2 pcs	4/20/18	4/20/18	0.00	0.00	Outsource4		
150	Packaging	2 pcs	4/20/18	4/20/18	0.00	0.00	Packaging2		
155	QC	2 pcs	4/20/18	4/20/18	0.00	0.00	QC5		
160	Small Fab	2 pcs	4/20/18	4/20/18	0.00	0.92	Small Fab-9		
170	QC	2 pcs	4/20/18	4/20/18	0.00	0.00	QC5		
180	Packaging	2 pcs	4/20/18	4/20/18	0.00	0.00	Packaging3-2		
190	QC21-SA	2 Ea	4/20/18	4/20/18	0.00	0.00	QC21		

Part Op 100 - Cut Blanks at 4.250"

Descriptions: 110 - 1-Machine per folio FB436 (D5354-2) DWG REV: _____ FOLIO REV: _____ 2- deburr and break all sharp edge as per dwg

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Outsource process-Anodize per QSI017 4.1.10.1

150 - Receive & Inspect for Damage & Mat'l Certs

155 - QC5- Inspect part completeness to step on W/O

160 - Assemble as per dwg. -Secure nuts as per dwg. (Note #8) -Apply proseal as per dwg. (Note #9)

Batch: _____ Exp. date: _____

170 - QC5- Inspect part completeness to step on W/O

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

P0039679.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X04.500	6061-T6 Bar 1.25 X 4.50	.7080 ft (.354 ea)	90-Start up Operation	S063263
D5316-1	T-Bolt Strap	5 2 Ea (1 ea)	160-Small Fab	F160682
D5351-1	T-Bolt Spacer	10 4 Ea (2 ea)	160-Small Fab	F160629x4
MS21043-3	Nut	10 4 Ea (2 ea)	160-Small Fab	S034534

HAS1149108324

10 2ea

S020006

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.250X04.500	1	18	0
160-Small Fab	D5316-1	2	14	0
	D5351-1	4	9	0
	MS21043-3	4	951	0

Part Specifications

Specifications could not be found.

Plex 3/28/18 11:10 AM Dart.Gagnon.Michelle

DART
AEROSPACE

Container No: S063265



Part: D5354-042

Job No: 174732

Serial No/Batch: S063265

Revision:

Inspector:

1414 PAVILION DRIVE
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/20/18

DART AEROSPACE LTD		Work Order:	174 732
Description: Support, RH		Part Number:	D5354-2
Inspection Dwg: D5354		Rev: C	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	+/-0.030	.495	✓		SLIO	Vein
Ø0.204	+0.005/-0.001	.204	✓			
0.20	+/-0.030	.195	✓			
0.279	+/-0.010	.277	✓			
Ø0.257	+0.005/-0.001	.259	✓			
1.28	+/-0.030	1.277	✓			
0.13	+/-0.030	.123	✓			
R0.25	+/-0.030	.250	✓		Rad gauge	
1.000	+/-0.005	1.000	✓		SLIO	Vein
1.67	+/-0.030	1.669	✓			
0.31	+/-0.030	.309	✓			
0.50	+/-0.030	.500	✓			
0.500	+/-0.005	.500	✓			
0.15	+/-0.030	.155	✓			
0.13	+/-0.030	.123	✓			
3.40	+/-0.030	3.390	✓			
R0.13	+/-0.030	.125	✓		Rad gauge	
0.25	+/-0.030	.248	✓			
1.00	+/-0.030	.998	✓			
94.8°	+/-0.5°	94.8°	✓		Protractor	
0.25	+/-0.030	.245	✓			
0.150	+0.015/-0.000	.155	✓			
0.250	+/-0.015	.248	✓			
0.65	+/-0.030	.652	✓			
R0.20	+/-0.030	.200	✓		Rad gauge	
R0.13	+/-0.030	.130	✓			
R0.25	+/-0.030	.250	✓			
3.06	+/-0.030	3.054	✓			
0.40	+/-0.030	.396	✓			
0.13	+/-0.030	.130	✓			
0.14	+/-0.030	.140	✓			
0.30	+/-0.030	.304	✓			

Measured by:	20 9.99	Checked by:	<i>[Signature]</i>	QC Inspector:	
Date:	18-04-20	Date:	18/04/26	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	<i>[Signature]</i>



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039679**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039679
PO Date: 4/23/18
Due Date: 4/27/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	174731	D5354-041	R66 Fwd Clamp Assembly, LH REF DART SPEC M6061T6B 2) FINISH : ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 3)TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED	Firmed	4/27/18	5 pcs	0 pcs SK	5 pcs	\$12.00/pcs	\$60.00

Line Item Note ** urgent**

2	174732	D5354-042	R66 Fwd Clamp Assembly, RH Outsource process-Black Anodize per QSI017 4.1.10.1 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED	Firmed	4/27/18	5 pcs	0 pcs JA	5 pcs	\$12.00/pcs	\$60.00
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Line Item Note **urgent**

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	176210	269T9319-1	Wrench -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color BLACK -Certificate of Conformity is required	Firmed	4/27/18	4 pcs	0 pcs 4/	4 pcs	\$37.50/pcs A1810427	\$150.00
Grand Total:										\$270.00
Order Notes rec'd A1810427 Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										



Certificat de Conformité / Certificate of Compliance

(008731-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

008731 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
27-Apr-2018		Aman		PO039679				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	D5354-041 Rev.	D5354-041 ANODIZE BLACK PER MIL-A-8325F TYPE I OR IB OR IC OR II OR IIB CLASS 2	ANODIZE CH	5	5	0	0	0
2	D5354-042 Rev.	D5354-042 ANODIZE BLACK PER MIL-A-8325F TYPE I OR IB OR IC OR II OR IIB CLASS 2	ANODIZE CH	5	5	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.